

SOW Attachment 1
NASA Overhaul Specifications
for
Spey Engines Mk 511-8

NA-4001-S		REPAIR OR OVERHAUL SPECIFICATION AND COMPLIANCE RECORDS	2	28
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PART I -		SPECIAL INSTRUCTIONS		
ENGINE SECTION:		WORK ORDER NO.		SERIAL NO.

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
76-A36	R	INSPECTION OF HP/SOC EMERGENCY LEVER.	ASSEMBLY				
72-A491	R+	INSPECTION OF REAR SLING BRACKET.	S/S BY MOD 3127				
72-A791	R	INSPECTION OF OIL TUBE TO BONDING LEAD TAG FOR POSSIBLE FOUL.	ASSEMBLY				
72-997	M	IMPROVED INSPECTION OF PRIMARY AIR SCOOPS.	SEE AD 87-18-07				
72-1023	R	LPT SHAFT SPLINE INSPECTION.					
72-1025	R	LPT ROTOR & INTERSTAGE SEAL INSPECTION.					
72-1043	M	CRACK TEST OF COMBUSTION CASE.					
N/A	R	X-RAY INSPECT DIFFUSER CASE P3 MANIFOLD WELDS SECURING THE AIR OFFTAKE PIPES, THE FOUR OIL TUBE SUPPORT BOSSES AT BDC, & ALSO AT ANY EXISTING REPAIR WELDS. FILMS FROM THESE INSPECTION, ALONG WITH ANY FOR NEWLY INCORPORATED REPAIRS, ARE TO BE PROVIDED TO SPEY CUSTOMER SERVICE FOR REVIEW BY NASA.					
N/A	R	TEST ENGINE TO CURRENT OHM REQUIRE- MENTS. ADDITIONALLY, ENSURE THAT N2 VS. THRUST FALLS WITHIN THE LIMITS OF NASA DWG NO.20650002, REV.A, Pt.V OF THIS SPECIFICATION.	TEST				
N/A	R	AT ENGINE TEST, ENSURE A MINIMUM OF 3 PSI MARGIN EXISTS FOR HOT ENGINE OIL PRESSURE. ADVISE ENGINEERING IF THIS CANNOT BE MET.	TEST				

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:		WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
2085	R+	THRUST REVERSER CLAMP RING WITH RE-POSITIONED LOCATION SLOTS.	SEE ALSO M3809 C/W IF REC'D WITH ENGINE				
2316 72-264	R	ENGINE BY-PASS DUCT P3 AIR TRANSFER TUBE WITH ADDITIONAL SEAL RINGS AT LINER END.					
2403 72-334	R	INTERMEDIATE SHAFT BALL BEARING OUTER RACE CUPWASHER INCORPORATING LOCATING TANGS.					
2411 72-335	A	INTERMEDIATE DRIVESHAFT STRENGTHENED ADJACENT TO THE FORWARD OIL HOLES.					
2573 72-427	R	HP1 TURBINE BLADE RETAINING PLATE WITH INCREASED RADIAL ENGAGEMENT.					
2574 72-407	R+	HP1 TURBINE SHAFT WITH POSITIVE STOP FOR TURBINE DISC DEFLECTION.	MOD 4412 ALSO REQUIRED				
2588 71-136	R	HARNESS CLIPPING BY SELECTIVE ASSEMBLY OF CLAMPS.	ASSEMBLY				
2609 72-421	A	HP ROTOR INNER & OUTER SPACERS WITH INCREASED SPIGOT CLEARANCE.					
2621 72-434	A	HP1 NGVs LOCATION RING PRODUCED IN ONE PIECE.					
2656 72-410	R	HP IGVs WITH ANTI-CORROSIVE TREATMENT.					
2658 72-417	R	ANTI-CORROSION TREATMENT OF STATOR VANES, ROTOR BLADES, & OGVs LP.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
2714 72-451	R	HP TURBINE BEARING OIL FEED & RETURN TUBE WITH BOLTED CONNECTORS.					
2724 72-415	A	STRONGER ANTI-ICING TUBE SUPPORT BRACKET.					
2782 72-450	R+	STRENGTHENED HP1 COMPRESSOR DISC WITH MODIFIED SEALING PANEL.	SEE MOD 3071				
2789 72-432	R	HP1 COMPRESSOR BLADE BUSHED PIN HOLES.					
2856 76-16	R	CONTROLS FFR LINKAGE WITH SERRATED RECTANGULAR WASHERS.					
2931 72-431	R	REVISED PIVOT BOLT LOCKING & BEARING LUBRICATION ON RAM TO IGV & BV EXTERNAL OPERATING LINKAGE.	SDI/ ASSEMBLY				
2936 79-10	R	OIL TANK WITH PRESSURE FILLER & OVERFILL STANDPIPE.					
2939 Pt.2&4 72-477	R+	AVICA 'V' CLAMPS - CLAMPS WITH FAIL-SAFE LINKS.	OR MOD 4454				
2941 72-513	R	CENTRAL OIL TUBE, REAR, OIL TRANSFER BUSH BORED AFTER ASSEMBLY.					
2947 72-445	R	OIL FEED & RETURN TUBES WITH CORRU-JOINTS FLATTENED ADJACENT TO BOLT HOLES.	ASSEMBLY				
2949 72-454	R	LP1 TO 5 BLADE RETAINING PINS WITH IMPROVED LOCKING FEATURES.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
2951 72-460	R	STAGES 1-4 (INCL) STATORS WITH CUT BACK LEADING EDGE OUTER PLATFORMS.					
2952 75-74	R	INCORPORATE END FLOAT BETWEEN SHAFT ASSEMBLY & SUPPORT BRACKET.					
2983 72-444	R	REMOVE FRONT SEAL FIN FROM SHAFT EXTENSION.					
2990 72-486	R+	STRONGER UPPER & LOWER REAR LIFTING BRACKETS.	SEE ALSO MOD 3127				
2991 72-488	R	LEFTHAND WHEELCASE OIL TUBE SLEEVE WITH INCREASED INTERFERENCE FIT.					
3002 72-453	R	HP1C BLADE WITH CUT BACK LEADING EDGE TIP.					
3025 72-483	A	APPLICATION OF ANTI-CORROSION TREATMENT TO BY-PASS DUCT SLIM LINE LINER.					
3026 72-459	R	CHROMIUM PLATED ROTATING SEAL SLEEVE & TUFFTRIDED RING SEAL.					
3055 75-67	A	HP AIR SUPPLY TOP SECTION IN 0.064" THICK S/CNT.					
3056 72-470	A	HP12 STEEL BLADE WITH AEROFOIL THICKENED BY 0.006" AT ROOT TAPERING TO ZERO AT TIP.					
3060 72-571	A	HP1&2 TURBINE INTERSTAGE AIR SEAL CROSS KEY LOCATED IN SUPPORT RING.					
3063 72-468	R+	INTERSTAGE SEALS. INTRODUCTION OF SPEY REPAIR SCHEME XRS-3505.	C/W ONLY. IF XRS 3505 REQUIRED				

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
3068 72-489	R	LARGE INTERCONNECTORS WITH SHROUD REMOVED & BOUNDARY LAYER COOLING.					
3071 72-485	R	HP1 BLADE RETAINING PINS WITH INCREASED CLEARANCE.					
3079 72-475	R	HP2,3,4,5,6 & 7 COMPRESSOR BLADES WITH CUT BACK TRAILING EDGE & RADIUS LEADING EDGE TIP.					
3085 72-410	R	FFR WITH INCREASED DIAMETER DRIVE, RETAINED BY SPRING RING.					
3116 72-458	R	HP COMPRESSOR ROTOR STRENGTHENED STAGES 8-9 TO 11-12 DISC SPACERS.					
3127 72-491	R	EXHAUST MIXER - STRONGER REAR LIFTING BRACKET.					
3148 72-508	A	HP IGV MECHANISM STOP RING DELETED.					
3158 72-492	A	HP COMPRESSOR STAGES 1,2, & 3 STATORS WITH DOWELS DELETED.					
3170 75-64	R	IGV CONTROL-SPRING LINK WITH TAPERED SHOULDER ON GUIDE ROD.					
3176 73-131	A	FEED TUBE WITH SPLIT CONNECTION, BACKING PUMP TO OIL COOLER.					
3177 76-18	R	EMERGENCY SHUT-DOWN REVISED CLIPPING OF EMERGENCY SOV CABLE.	ASSEMBLY				
3194 72-545	R	HP2 DISC INNER TRIPLE SEAL WITH ADDITIONAL SLOTS.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
3199 72-500	A	CONSTANT SECTION LOCATING RING.					
3200 72-606	A	DISCHARGE NOZZLE REAR FRAME IN S31 MATERIAL.					
3252 72-577	A	FRONT BEARING RING SEAL WITH CHROMIUM PLATED ROTATING MEMBER & TUFFTRIDED RING.					
3270 72-523	A	LP OGVs BONDED INTO SEGMENTS WITH ECCOBOND 104.					
3279 72-480	R	TACK WELDING OF COMBUSTION LINER BOLTS.	ASSEMBLY				
3281 72-501	R	INTERFERENCE FIT OF LINER INTER-CONNECTOR INTERLOCKING FEATURES.					
3289 72-487	R	COMPRESSOR LP1 ROTOR BLADE WITH CUT BACK TRAILING EDGE.					
3301 72-531	A	DISCHARGE NOZZLE WITH REDUCED WIDTH COOLING RINGS.					
3336 72-526	R+	INTRODUCTION OF BRAZED WIRE GAUZE STRAINERS.	ORDER 5 EACH P/N DA12652				
3343 72-502	M	OIL RETURN SOLEPLATE WITH EXTENDED LINER.	PRE-MOD 3700 ONLY				
3358 72-503	A	DISCHARGE NOZZLES WITH ADDITIONAL ROW OF COOLING HOLES.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
3374 72-587	A	BY-PASS AIR FAIRINGS STRENGTHENED & WITH CUT OUT TO SUIT 6-SPOKE BEARING HOUSINGS.					
3382 72-609	A	LP3 STATOR WITH THICKER AEROFOIL AT OUTER END.					
3383 72-529	R	INTERNAL CASE - LP OGV LOCATING RING COATED WITH PROTECTIVE VARNISH.					
3387 75-97	R	PV RAM TO IGVs & BV OPERATING LINKAGE WITH "D" HEADED PIVOT PINS SECURED BY NUTS.					
3420 72-511	R+	RE-ROUTED OIL FEED TUBE TO HP TURBINE BEARING.	N/A TO MOD 5277				
3425 72-593	R	COMMON 0.50" LONG NO.10 BOLTS IN A.C.N. MATERIAL.					
3437 72-559	A	DELETION OF ANNULUS GROOVE FROM REAR FLANGE BEARING HOUSING.					
3443 76-15	R+	REMOVAL OF TOP TEMPERATURE REDATUM MICRO SWITCH BOX.	N/A TO MOD 3604				
3444 72-517	R	STAGE 4 ROTOR BLADE WITH CUT BACK LEADING & TRAILING EDGE TIPS & HIGH MINIMUM FIRST TORSIONAL FREQUENCY.					
3460 76-23	A	F.S.O.V. CABLE WITH SHORTENED FORWARD SECTION.					
3488 76-17	R	HEXAGON BOLTS FOR SECURING THROTTLE RELAY LEVER BRACKET.					
3521 72-655	A	LS DRIVE GEARSHAFT WITHOUT CHAMFER & RECESSED RINGNUT.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
3528 72-556	R	P3 AIR TAPPING HOLE WITH DRESSED CORNERS TO GIVE MAXIMUM AREA.					
3555 75-86	R+	CROSSOVER TUBE CENTER SECTION BOUND WITH STAINLESS STEEL BRAIDING.	REF. AD 68-17-5				
3560 72-549	R	CHROME PLATED ROTATING SEAL & TUFFTRIDED RING.					
3583 72-561	R	HP1&2 TURBINE DISCS WITH SCALLOPED DRIVING FLANGES.					
3603 73-132	R	LP FUEL RETURN TUBE FROM IGV RAM TO FILTER WITH CENTER DISCONNECT.					
3637 72-610	R	GEARBOX RH FUEL BACKING PUMP DRIVESHAFT WITH DEEPER UNDERCUT.					
3546 72-572	A	LP TURBINE STAGE 1 DISC LOCATING SLEEVE WITH INCREASED DIAMETRAL SHAFT INTERFERENCE.					
3664 75-99	R	INCREASED BEARING CLEARANCE & PL94 APPLIED TO SPLINES.					
3684 72-585	R	COOLING AIR COLLECTOR-MANIFOLD WITH EXTERNAL & INTERNAL PROTECTIVE COATING.					
3690 72-676	A	LP1 DISC ASSEMBLY SLEEVE END MACHINED FLUSH WITH HUB.					
3698 72-582	R	SHARP CORNERS RADIUSSED TO PROVIDE FOR IMPROVED ANTI-CORROSION TREATMENT.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
3700 72-614	A	REAR DUCT WITH SLIM LINE PROFILE & SIMPLIFIED SOLEPLATES.					
3767 75-94	R	BLEED VALVE MECHANISM SUPPORT BRACKET DOWELS DELETED.					
3777 75-100	R+	FUEL HEATER AIR FEED TUBE WITH INCREASED END FLOAT.	N/A TO MOD 4391				
3790 72-566	R	WAISTED BOLTS TO SECURE ROTATING SEAL TO HP2 DISCS.					
3809 72-578	R+	EXHAUST MIXER & THRUST REVERSER - THICKER CLAMP RING WITH BAULKING FEATURE.	C/W IF RECEIVED WITH ENGINE				
3816 72-608	R+	COVERS TO PARTIALLY SEAL OFF SLAVE LEVER BEARINGS.	SEE ALSO MOD 4621				
3858 72-597	A	HP COMPRESSOR FAIRINGS WITH BUSHED BOLT HOLES.					
3886 72-564	R+	INTRODUCTION OF XRS 3663. TURBINE DISC LOCKPLATE GROOVE REPAIR.	ALSO SEE MOD 4911				
3889 72-575	R	SEALING RING OF IMPROVED QUALITY AT FRONT BEARING HOUSING TO PUMP HOUSING JOINT.					
3892 72-599	R+	METERING AREAS ADJUSTED TO INCREASE AIR FLOW TO LP INTERSTAGE SEAL. (MUST BE C/W IN FULL EXCEPT MODs 4412/5870 MAY BE FITTED SEPARATELY).					
3904 72-583	A	EFFUSION COOLED DISCHARGE NOZZLE.					
3916 72-636	R+	HP TURBINE BEARING OIL SEALING RING ASSEMBLY. C/W WITH CROSS KEY LOCATION & INCREASED AXIAL CLEARANCE FOR RING & RETAINING PLATE.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
3917 72-600	A	LP2 ROTOR BLADE WITH THICKENED ROOT.					
3929 72-627	A	THICKER FLANGE ON NGV SUPPORT RING FOR LP TURBINE INTERSTAGE SEAL SECURING BOLTS.					
3931 80-37	R+	IGNITER SLEEVE BOLT IN LINER SPRAYED WITH METCOLOY 2.	C/W AS REPAIR ONLY			-	
3934 72-580	R	DELETION OF TUFFTRIDING & SILVERPLATE FROM HP STATOR VANES & CASE & PL-101 APPLIED.					
3971 72-639	A	EXTERNALLY ACCESSIBLE ADJUSTABLE INTERNAL STOP FOR HP COMPRESSOR IGVs.					
4012 72-622	A	DIFFUSER CASE HIGH PRESSURE CENTER BEARING VENT TUBE WITH RECTANGULAR SECTION SEALS.					
4026 72-616	R+	LP OGV SEGMENTS SECURED WITH 0.025" UNF BOLTS.	C/W MOD 5270				
4196	A	HP2 & LP1 NGVs SUPPORT RING WITH THICKER LOCATING GROOVE WALLS.					
4243 72-646	R+	HP IGV INTERNAL STOP MECHANISM WITH INCREASED CLEARANCE CAMSHAFT & SPRING LOCKING PLUNGER.	C/W ON MOD 3971 STD. ONLY				
4260 72-626	R	HP2 TO 7 BLADES WITH CHAMFERED LEADING EDGE TIP.					
4265 72-642	A	INTERCONNECTOR STUB PIPES SLIDING MEMBER WITH MODIFIED LIP.					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
4282 72-629	A	ANTI-ICING MANIFOLD OUTLET CONNECTION IN S607.					
4295 76-25	A	RELAY & SOV CONTROL RODS WITH INCREASED LENGTH RIVETS.					
4340 72-643	R+	STAGE 2 TO 12 BLADES & DISCS PAINTED & WET ASSEMBLED WITH LP101.	ASSEMBLY				
4362 72-752	A	INCREASED LENGTH DOWELS FOR ACCESSORY RAFT SUSPENSION BRACKETS.					
4391 75-128	A	FUEL HEATER RIGID AIR FEED TUBE REPLACED BY A FLEXIBLE AIR FEED HOSE.					
4398 72-692	R	CASE FRONT FLANGE DRAIN SLOTS REPLACED BY DRAIN HOLES.					
4411 75-126	A	VIBRATION DAMPED FLEXIBLE MOUNTING FOR ANTI-ICING VALVES.					
4412 72-718	R+	STRENGTHENED HP STAGE 2 TURBINE DISC LOCATION SLEEVE WITH THRUST WASHER DELETED.	or MOD 5870 or 6142				
4422 72-702	R+	HP INLET GUIDE VANE OPERATING TRUNNIONS IN BRONZE/PTFE MATERIAL INSTEAD OF 'TUFNOL'.	OR MOD 5584				
4424 72-690	R	HP COMPRESSOR IGV PIVOT BUSHES IN 'VESPEL' MATERIAL.					
4443 79-11	R	DELETION OF OIL TANK OVERFILL STAND TUBE CLIPPING.					
4454 72-652	R+	AVICA CLAMPS WITH IMPROVED NON-CORRODIBLE FAIL-SAFE LINKS. (C/W ON FUEL SYSTEM CLAMPS).					

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BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
4456 72-688	R	HP THRUST BEARING OIL SCAVENGE TUBE WITH SPHERICAL NIPPLE SEAL AT OIL SUMP.					
4457 75-111	R	QUILLSHAFT SUPPORT BODY THRUST WASHERS SECURED WITH 'ECCOBOND'.					
4469 72-657	R+	LP COOLING AIR OUTLET OIL TRAP.	ALSO C/W MOD 4734				
4474 72-685	R	REVISED BUILD TECHNIQUE FOR STAGE 1-11 HP ROTOR DISCS.	ASSEMBLY				
4496 72-671	R	BEARING OIL FEED TUBE WITH INTEGRAL SPIGOT AT SPLIT CONNECTOR.					
4506 72-672	A	BEARING SUPPORT SPOKES WITH THIN WALLED CAST END PIECES.					
4526 72-683	R	HP TURBINE SHAFT LOCKING PLUNGER SPRING IN S/SW MATERIAL.					
4536 72-673	R	DELETION OF LINER/DISCHARGE NOZZLE RIGHTHAND ANCHOR NUT & BOLT.					
4540 72-715	M	STAGES 2 TO 3 ROTOR DISCS WITH INCREASED THICKNESS DIAPHRAGM.					
	R	STAGES 4 TO 5 ROTOR DISCS WITH INCREASED THICKNESS NECK & DIAPHRAGM.					
4541 72-706	R	STRENGTHENED STAGES 10 & 11 ROTOR DISCS WITH STAGE 10 & 11 SPACER TO SUIT.					
4577	R+	INCREASED INTERFERENCE BETWEEN LPC FRONT BEARING RACE & HOUSING.	ALSO C/W MOD 4990				
4590 72-679	R+	APPLICATION OF 'NICOAT 4' TO DISCHARGE NOZZLE INNER WALL.	C/W XRS 3751 IF REPAIR REQUIRED				

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4621 72-699	R	BLEED VALVE SLAVE LEVER BEARING INNER DUST COVERS WITH ANGULAR LOCATION FEATURE.					
4629 72-691	R+	MODIFIED BRACKET FOR ATTACHING BACKING PUMP TO FCOC LP FUEL FEED PIPE CLIP.	C/W ONLY IF MOD 3176 PCW				
4669 75-125	R	P3 AIR TUBE WITH FLEXIBLE SECTION & UNION CONNECTIONS.					
4697 72-724	R	INCREASED DIAMETER BOLTS SECURING AIR DEFLECTOR PLATE TO STAGE 12 SEAL SUPPORT.					
4701 72-700	A	STAGE 1 ROTOR DISC - INTRODUCTION OF A REPAIR SCHEME TO RECLAIM THE RETAINING PLATE GROOVE.					
4709 72-727	R+	SHOTPEENING OF DOVETAIL ROOTS. STAGES 2-12 HP BLADES.	C/W XRS 3991				
4718 71-126	R	REVISED FUEL DRAINS SYSTEM TO PREVENT FLOODING OF THE FUEL FLOW REGULATOR CAPSULE HOUSING.					
4719 72-714	R+	ALTERNATOR EJECTOR VALVE SUPPORTING BRACKET WITH REVISED LOCATING SADDLE.	C/W ONLY IF MOD 4308 C/W ON VALVE				
4734 72-717	R+	OIL TRAP WITH MODIFIED DRAIN TUBE. HP TURBINE CASING LOWER SUPPORT STRUT..	SEE MOD 4469				
4736 72-749	R	ORIFICE PLATE FITTED AT SPLIT CONNECTION OF INTERNAL WHEEL CASE TO DRAINS TANK VENT PIPE.					
4765 72-711	R	HP TURBINE BEARING SUPPORT, BEARING HOUSING & DIFFUSER CASE SECURED BY 0.250" DIAMETER WAISTED BOLTS.					
4774 72-742	R+	STRENGTHENED OIL SEAL RING HOUSING & IMPROVED SEALING.					

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4775 72-729	R	ENGINE OIL PUMP WITH INCREASED HP TURBINE BEARING SCAVENGE CAPACITY.					
4789 72-712	R	DELETION OF GENERATOR & ALTERNATOR SHEAR-NECK QUILLSHAFT SOFT STOP BUSHES.					
4793 72-744	R	PIN-LOCATED AIR SEAL RING IN HAYNES 25 & MATING FACES OF SEAL HOUSING & SEAL SLEEVE COATED WITH METCOLOY 2.					
4806 72-759	R+	HP2, LP1 & 2 GUIDE VANE SUPPORT RINGS WITH METCO 404 COATING ON FRONT FACE OR REAR LOCATING GROOVE.	C/W TO REPAIR ONLY				
4815 76-28	R	THROTTLE RELAY LEVER PIN BUSH, WITH BUSHED INTERFERENCE & RETAINED BY LOCKTITE.					
4816 76-30	R	INCREASED CLEARANCE BETWEEN THROTTLE RELAY LEVER SPINDLE & LP COMPRESSOR CASE.					
4843 72-753	R+	INLET GUIDE VANES INTERNAL ADJUSTING MECHANISM GEAR LOCKING LEVER WITH REDUCED TOOTH LENGTH.	APPLIES TO MOD 3971, 4243 ONLY				
4847 72-755	R	STAGE 6 ROTOR DISC WITH INCREASED THICKNESS NECK & DIAPHRAGM.					
4855 72-734	R	AIR SUPPLY RESTRICTOR TO DC GENERATOR AIRBLOWN SEAL WITH INCREASED DIAMETER ORIFICE.					
4911 72-736	R+	BLADE RETAINING PLATE WITH INCREASED RADIAL ENGAGEMENT & HAYNES INNER LOCATING STRIPS.	C/W XRS 3663 & MOD 3886 IF MOD 4911 NOT PCW				
4965	R+	FUEL DRAINS BLANKED AT BY-PASS DUCT & HP SOC.	ALSO C/W MOD 5298				

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:		WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
4977 72-790	R	STAGE 4,5 & 6 STATOR VANES WITH AERO-FOIL THICKNESS INCREASED AT OUTER END.					
4982 72-787	R	RUBBER WEIR FOR OIL RETENTION AT HP COMPRESSOR/INTERNAL GEARBOX SHAFT SPLINES.					
4987 72-803	R	BEARING SUPPORT WITH GUIDE PLATES IN HAYNES 25 MATERIAL & THICKENED HAYNES 25 SLIDING BAND ON SPOKE FAIRINGS.					
4990 72-772	R	IMPROVED FIT BETWEEN FRONT BEARING HOUSING & SUPPORT.					
4996 72-779	R	STRENGTHENED SUPPORT BRACKETS FOR OIL FEED & DRAIN TUBES.					
5000 72-785	R+	REVISED SETTING INSTRUCTION FOR HP COMPRESSOR INLET GUIDE VANE MECHANISM.	C/W ONLY IF MOD 3971 PCW. ASSEMBLY				
5021 72-771	R	AIR SUPPLY RESTRICTOR TO BREATHER AIR BLOWN SEAL WITH INCREASED VANE MECHANISM.					
5022	A	HP & LP COMPRESSORS - LP FRONT BEARING & HP THRUST BEARING OIL SEAL SLEEVES WITH PRE-FINISHED SEALING DIAMETER.					
5023 75-129	R+	CROSS-OVER TUBE CENTER SECTION BORE MACHINED TO ACCOMMODATE HTE 4138 NON-RETURN VALVE.	N/R UNLESS MOD 4795 PCW.				
5039 72-770	R	THRUST BEARING REAR OIL SEAL WITH GROOVED STATIC MEMBER.					
5047 72-788	R	STRENGTHENED LOCKPLATE WITH BAULKING FEATURE FOR HP THRUST BEARING OIL RETURN TUBE.					

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PART II - MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION	WORK ORDER NO.	SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
5061 72-768	A	STAGE 2 ROTOR DISC. INTRODUCTION OF REPAIR SCHEME TO RECLAIM BLADE RETAINING PLATE GROOVE.					
5062 72-799	A	MATERIAL OF TAPER BOLTS CHANGED FROM STEEL TO NIMONIC 90.					
5073 72-782	R+	HP PILOT FUEL FEED TUBE RERUN TO SHUT-OFF VALVE FROM ALTERNATIVE CONNECTION ON FUEL FLOW REGULATOR.	CP 4407 REQUIRED ON FFR				
5084 72-778	A	MODIFIED SEAL CARRIER FOR LP TURBINE BEARING OIL FEED & RETURN CONNECTORS IN REAR BY-PASS DUCT.					
5097 72-797	A	DRIVESHAFT STRENGTHENED ADJACENT TO FORWARD OIL FEED HOLES.					
5112 72-798	R+	DELETION OF RETAINING STRIPS FOR HP TURBINE BEARING ACCESS HOLE COVER SECURING BOLTS.	ALSO SEE MODs 5843 & 5987				
5158 72-808	R	STATOR QUADRANTS WITH HAYNES 25 BUSHED & CHROMIUM PLATED DOWEL PINS.					
5181	R	LP COMPRESSOR - STAGE 2,3, & 4 STATOR QUADRANTS WITH INNER SHROUD RIVETS TACK WELDED TO SACKING PLATES.					
5182 72-838	R	STAGE 1 STATOR QUADRANTS WITH DOWEL BOSSES HAVING INTEGRAL RIVETS.					
5254 72-817	R	LPT BEARING WITH REDUCED SNUBBER CLEARANCE.					
5270 72-812	R	INTERNAL GEARBOX - LP COMPRESSOR OUTLET GUIDE VANE INNER FIXING BOLTS IN S/ABV MATERIAL.					
5273 72-818	R+	BLEED VALVE - STRENGTHENED ATTACHMENT LUGS.	SEE MOD 5474				
5282 72-821	R+	HP TURBINE BEARING REAR SEAL HOUSING REDUCED IN THICKNESS.					

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS		
ENGINE SECTION:		WORK ORDER NO.		SERIAL NO.

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
5283 72-830	R	SERMETEL W ANTI-CORROSION TREATMENT HP DISCS & SPACERS.					
5298	R+	REMOVAL OF MOD 4965 BLANKING PLATE.	ASSEMBLY				
5315 76-34	R	EMERGENCY HP/SOC CABLE DISCONNECT PULLEY LOCKED BY SHEAR WIRE.					
5342	R	INTRODUCTION OF RE-CIRCULATING NON-OVERBOARD FUEL DRAIN SYSTEM.					
5390	R	OIL PUMP CENTER BEARING SCAVENGE BOBBIN WITH .071" DRAIN HOLE.					
5418 72-841	R	HP TURBINE BEARING & SUPPORT & DRAIN TUBE VALVES & FITTINGS COMBUSTION CASE WITH EXTENDED FUEL DRAIN SLOT BLANKING PLATE REPLACED BY NON-RETURN VALVE.					
5449	R	LPC BLADE PINS TEMPERED AT REDUCED TEMPERATURE.					
5474	R+	AIRFLOW CONTROL BLEED VALVE - BLEED VALVE WITH INCREASED FILLET RADIUS AT ATTACHMENT LUGS.	C/W IF MOD 5273 NOT PCW				
5475	R	HP COMPRESSOR STRENGTHENED 9 TO 10 SPACER.					
5484	R	ENGINE DIFFUSER CASE DELETION OF HP COMPRESSOR STAGE 12 SEAL AIR DEFLECTOR PLATE.					
5490	R+	ENGINE EXHAUST MIXER JET PIPE TO EXHAUST MIXER RETAINING RING WITH CUTOUTS TO CLEAR JET PIPE BRACKETS.	IF RECEIVED				
5521	R	LP COMPRESSOR STATOR VANE LOCATING GROOVES COATED WITH SILASTIC OR SILCOSET RUBBER COMPOUND.	ASSEMBLY				

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PART II -	MANUFACTURERS BULLETIN COMPLIANCE RECORDS		
ENGINE SECTION:	WORK ORDER NO.	SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
5546	R	AIR - AIRFLOW CONTROL REGULATOR & ACTUATOR - INTRODUCTION OF CONTINUOUS FUEL BLEED SYSTEM.					
5548	R	BY-PASS DUCT - REAR DUCT BLANKING SET-SCREW REPLACED BY GRUBSCREW.					
5549	R+	HP TURBINE - RE-INTRODUCTION OF AIR SEAL ASSEMBLY TO SUIT FORGED STAGE 1 BLADES.	IF MOD 5834 C/W ONLY				
5582 72-873	R	HP TURBINE - BEARING OUTER RACE KEYED TO BEARING HOUSING & WITH AXIAL TIP DELETED.					
5584	A	INTERNAL GEARBOX HP INLET GUIDE VANE OPERATING TRUNNIONS IN VESPEL SO21 MATERIAL. (C/W ON REPLACEMENT OR IN LIEU OF MOD 4422).					
5639 79-12	R	OIL FILTER - INTRODUCTION OF FILTER ELEMENT ANTI-ROTATION COMPRESSION WASHER.					
5649	R+	CONTROLS - THROTTLE CONTROL ROD WITH VIBRATION DAMPING SLEEVE.	S/S BY MOD 6022				
5673	R+	OIL SUMP & HP THRUST BEARING SECURED TO BEARING HOUSING WITH STUDS INSTEAD OF BOLTS.	ALSO C/W TI-127				
5674	A	TUBES - FUEL CONTROL UNIT TO FILTER RETURN TUBE RE-RUN TO CLEAR A FOUL.					
5675	R	HP TURBINE - SHAFT WITH THREADS DELETED FROM SECONDARY RETAINING DOGS.					
5729	R	OIL PUMP SCAVENGE BOBBIN FROM HP TURBINE BEARING WITH .052" DRAIN HOLE.					
5731 72-881	A	TUBES - INTERNAL GEARBOX TO SCAVENGE OIL DRAIN TUBE RE-RUN.					

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:		WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
5819	R	FUEL - REPOSITIONED CLIPPING FOR FUEL DRAIN TUBE.					
5824	R	HP TURBINE - STAGE 1 DISC WITH INCREASED BLENDING RADIUS ON FIRTREE BUCKET GROOVES.					
5851	R+	NOZZLE CASE - GUIDE VANE SUPPORT RINGS WITH METCO 404 ON REAR FACE OF LOCATING GROOVE.	C/W TO REPAIR ONLY				
5843	R+	BEARING & SUPPORT - ACCESS HOLE COVERS SECURED WITH ADDITIONAL BOLTS.	ALSO C/W MOD 5987				
5844	A	HP12C & TURBINE AIR SEALS WITH REDUCED CLEARANCE.	C/W ON REPLACE MENT ONLY				
5870	A	STRENGTHENED HP2T DISC SLEEVE.					
5916	R	COOLING AIR GUIDE TUBE SEALING RINGS IN VITON (E.60C) INSTEAD OF VITON (VE/HT).	ASSEMBLY				
5919	A	HPC VANES WITH IMPROVED SURFACE FINISH.	C/W TI-259				
5963 72-938	R+	REVISED SETTING INSTRUCTIONS FOR ALUMINUM VALVE.	C/W TI-323 ASSEMBLY				
5987 72-954	R	BEARING & SUPPORT - ACCESS HOLE COVERS WITH SHORTER BOLTS & WITH WASHERS DELETED.					
5991 72-960	R	STARTER IDLER GEAR FRONT BEARING OUTER RACE WITH INCREASED DIAMETER RETAINING STUDS.					
6007	A	STAGE 2 HP TURBINE SEAL SEGMENTS WITH SEALING PLATES AT INTER-SEGMENT GAPS.					

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ENGINE SECTION:		WORK ORDER NO.	SERIAL NO.

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
6022	R+	RELAY LEVER TO FCU WITH INCREASED DIAMETER SCREW THREAD.	DELETE MOD 5649				
6033	R+	STAGE 1 LPC STATOR QUADRANT WITH CHAMFERED DOWEL BOSSES & LP ROTOR RE-SET.					
6040	R	AIRFLOW CONTROL BLEED VALVE RE-INTRODUCTION OF BLEED VALVE OPERATING & SUPPORT LEVER BUSHES IN GLACIER MATERIAL (REMOVAL OF MOD 5866).					
6104	R+	HPC CASE PROTECTED WITH SERMETEL W.	IF PCW				
6112	R	REVERSION TO PRE-MOD 6001 CONFIGURATION.					
6114	R	FRONT MOUNT SECURING NUTS UNPLATED.					
6116	R	LPIC VANE INNER SHROUD RIVETS TACK WELDED.					
6121	CR	'TRANSPLY' COMBUSTION LINERS.					
6142	A	HP2T DISC SLEEVE IN EFR MATERIAL.					
6154	R	BLEED VALVE SPHERICAL BEARING HOUSING WITH ENLARGED BORE.					
6162	R	HP1T BLADE LOCKPLATES WITH ANTI-FRETTAGE WIRE.					
6163	R	OIL PUMP LP TURBINE BEARING SCAVENGE BOBBIN WITH .052" DRAIN HOLE.					

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:	BLADE, TURBINE	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
2970 72-581	R	HP1 BLADE WITH IMPROVED COOLING. <u>NOTE 1:</u> IF MODIFICATION COMPLIANCE IS REQUIRED, A FULL SET OF MOD 5110, OR LATER STANDARD ARE TO BE INSTALLED. <u>NOTE 2:</u> S/S BY MODs 5086, 5098, 5070, 4976, 5110, & 5118.					
4921	R+	ALUMINIZED HP2T BLADES.	S/S BY MOD 5581				
5518	R+	HP1 TURBINE BLADES WITH INCREASED RADII ON ROOT NECK CORNERS.	C/W ON MOD 5110 STD.				
5581	R	HP TURBINE - STAGE 2 TURBINE BLADE WITH AIRFOIL PARTIALLY ALUMINIZED.					
5642	R+	HP TURBINE STAGE 1 BLADES WITH REDUCED CLEARANCE BETWEEN SHROUD INTERFACES.	C/W TI-034 (N/A TO MOD 5834 BLADES)				
5834	CR	HP1T BLADES WITH REVISED AIRFOIL TO IMPROVE PERFORMANCE.	MIN. STD ON 511-8 & 511-10				
6043	A	HP1T BLADES WITH INCREASED ROOT FLEXIBILITY.					
6061	A	HP2T BLADES PRODUCED BY CREEP FEED GRINDING.					
5892	R+	APPLICATION OF CABOT 694 (COASTMETAL 64) TO HP1 BLADE SHROUD INTERFACES.	C/W TI-034				

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:	BEARINGS	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
2723 72-426	R+	HP COMPRESSOR FRONT ROLLER BEARING CAGE BAR INNER CORNERS REMOVED.	C/W BY RE- PLACING BEARING				
3040 72-504	R	LOCATION BEARING WITH STRENGTHENED OUTER CENTERED RETAINER.					
3598 72-696	A	HP BEARING SLEEVE IN RBD MATERIAL.					
4698 72-733	A	HIGH PRESSURE TURBINE BEARING SLEEVE WITH EXTENDED CHROMIUM PLATING.					
4844 72-751	A	BEARING WITH INCREASED DIAMETER RIVETS IN CAGE.					
5050 72-804 Pts.1&2	A	MAINSHAFT BALL & ROLLER BEARINGS WITH OUTER RACES IN ELECTROFLUX REMELTED (EFR) TOOL STEEL.					
5050 72-804 Pt.3	R	LPC THRUST (INTERSTAGE) BEARING IN EFR MATERIAL.					
5582	R	HP TURBINE BEARING OUTER RACE KEYED TO BEARING HOUSING WITH AXIAL NIP DELETED.					
5831	R	LP COMPRESSOR INTRODUCTION OF FRONT ROLLER BEARING WITH CLEARANCE AT OUTER RACE LOCATION.					
5991	R	STARTER IDLER GEAR FRONT BEARING OUTER RACE WITH INCREASED DIAMETER STUDS.					

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SOW Attachment 2
NASA Specifications for Turbine Midlife
and Calendar Life Inspections
for
Spey Engines Mk 511-8

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PART 1		SPECIAL INSTRUCTIONS - DISASSEMBLY			
WORK ORDER NO.		ENGINE SERIAL NO.		CUSTOMER	NASA

ITEM	WORK TO BE PERFORMED	INSP
1.	INSPECT OIL SCREENS, CHIP DETECTORS, & OIL FILTER.	
2.	REMOVE LPC ROTOR & DEBLADE COMPLETELY.	
3.	REMOVE LPC HALF CASES & VANES.	
4.	VISUALLY INSPECT LPC OGVs, & REMOVE IF MOD 5270 NOT PCW. (P/N K186114 BOLTS INSTALLED).	
5.	VISUALLY CHECK THE LPC REAR BEARING IN-SITU FOR OBVIOUS DAMAGE, & ENSURE THAT BEARING RETAINING NUTS ARE NOT LOOSE.	
6.	DISASSEMBLE FRONT BEARING HOUSING TO RE-PROTECT. ROUTE LPC FRONT BEARING & RACE FOR OVERHAUL INSPECTION & MOD 5831.	
7.	DISASSEMBLE THE TURBINE SUFFICIENTLY TO REMOVE ALL VANES & SEAL CARRIERS, THE HP1 & 2 TURBINE BLADES, THE HP TURBINE BEARING & SEAL, & THE HP DISCS & SHAFT. REMOVE THE HP2T DISC SLEEVE.	
8.	VISUALLY INSPECT LPT BLADES, DISCS, LOCKPLATES, & NGVs FOR OBVIOUS DEFECTS. DEBLADE OR ROUTE FOR REPAIR AS REQUIRED. REMOVE THE LP1T DISC SLEEVE IF DISPLACED.	
9.	DISASSEMBLE THE LP1 & LP2 NGV SUPPORTS.	
10.	DISASSEMBLE THE COMBUSTION LINERS & DISCHARGE NOZZLES, & REMOVE THE PRIMARY AIR SCOOPS.	
11.	DISASSEMBLE THE HPC ROTOR SUFFICIENTLY TO REMOVE THE AIR GUIDE TUBE. ROUTE THE INTERSHAFT THRUST BEARING FOR OVERHAUL INSPECTION.	
12.	DEBLADE & DEVANE HPC ASSEMBLY COMPLETELY.	
13.	DISASSEMBLE THE DIFFUSER CASE COMPLETELY. ROUTE THE CENTER BEARING FOR OVERHAUL INSPECTION.	
14.	DISASSEMBLE THE BLEED VALVE ASSEMBLY COMPLETELY FOR OVERHAUL INSPECTION. COMPLY WITH TI-155.	
15.	CHECK THE HPC FRONT BEARING RETAINING NUTS FOR LOOSENESS.	
16.	REMOVE THE HPC IGVs & THEIR OPERATING MECHANISM.	

PART - I -		SPECIAL INSTRUCTIONS - DISASSEMBLY			
WORK ORDER NO.		ENGINE SERIAL NO.		CUSTOMER	NASA

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PART I -	SPECIAL INSTRUCTIONS - WORK TO BE PERFORMED		
WORK ORDER NO.	ENGINE SERIAL NO.	CUSTOMER	NASA

ITEM	WORK TO BE PERFORMED	FUNCTION	INSP
1.	CLEAN & CRACK TEST ALL REMOVED COMPONENTS & ALL MAJOR COMPONENTS WHICH HAVE BEEN COMPLETELY DISASSEMBLED. CRACK TEST ALL HPC BLADES, VANES, & DISCS & SPACERS.		
2.	RE-PROFILE, CRACK TEST, & RE-PROTECT WITH PL205 ALL LPC BLADES & COMPLY WITH MOD 6269.		
3.	CRACK TEST ALL LPC BLADE PINS.		
4.	RE-PROTECT LPC VANES & NOSE FAIRINGS WITH PL205.		
5.	RE-PROTECT LPC HALF CASES I/A/W XRS 5087.		
6.	RE-PROTECT THE FRONT BEARING HOUSING.		
7.	OVERHAUL INSPECT ALL REMOVED BEARINGS.	BEARING	
8.	OVERHAUL INSPECT HPC IGVs, THEIR OPERATING TRUNNIONS, & THEIR SUPPORT MEMBERS & BUSHINGS.		
9.	VISUALLY INSPECT HPC BLADES & VANES FOR FOD, CORROSION, WORN ABUTMENT FACES, OR WORN PLATFORM FEET.		
10.	VISUALLY INSPECT HPC DISCS FOR CORROSION & DEFECTS, PAYING PARTICULAR ATTENTION TO THE DOVETAILS. C/W MOD 5283, IF RE-PROTECTION IS REQUIRED.		
11.	VISUALLY INSPECT ALL HPC SPACERS FOR WEAR OF THE FACES & CORROSION.		
12.	VISUALLY INSPECT HPC SHAFT TEETH & THREADS FOR CORROSION & DAMAGE.		
13.	COMPLY WITH Sp72-997 ON THE PRIMARY AIR SCOOPS & INSPECT TO CURRENT OVERHAUL MANUAL STANDARDS.		
14.	OVERHAUL INSPECT THE BLEED VALVE & ALL OF ITS OPERATING HARDWARE. C/W TI-155 & TI-323.		
15.	WEIGH BLEED VALVE LINK SPRINGS & ALL OIL SYSTEM RELIEF VALVE SPRINGS (EXCEPT OIL COOLER BY-PASS) TO OHM REQUIREMENTS.		
16.	OVERHAUL INSPECT & REPAIR THE COMBUSTION LINERS & DISCHARGE NOZZLES.		

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WORK ORDER NO.	ENGINE SERIAL NO. CUSTOMER: NASA

ITEM	WORK TO BE PERFORMED	FUNCTION	INSP
17.	CRACK TEST & VISUALLY INSPECT THE COMBUSTION OUTER CASING FLANGE, OUTER FLANGE FACE, & CYLINDRICAL SECTION FOR EVIDENCE OF FRETAGE, SCORING OF THE BORE, & CRACKING. RE-PROTECT, IF REQUIRED.		
18.	OVERHAUL INSPECT THE HPT BEARING SUPPORT & ITS COMPONENTS, INCLUDING AIR & OIL SEALS.		
19.	OVERHAUL INSPECT NOZZLE CASE & HP2 NGV SUPPORT.		
20.	OVERHAUL INSPECT HP1&2 TURBINE BLADES. RE-ALUMINIZE THE HP1 BLADES & PRE-MOD 5581 HP2 BLADES. OVERHAUL INSPECT HP1&2 NGVs.	MCA	
21.	OVERHAUL INSPECT HP1&2 TURBINE DISCS, SHAFT, & SLEEVE.		
22.	CRACK TEST & VISUALLY INSPECT LP1&2 NGV SUPPORTS.		
23.	VISUALLY INSPECT LPT BEARING SUPPORT CONE & FAIRINGS FOR FRETAGE & CRACKING.		
24.	CRACK TEST THE REAR SUSPENSION LINKS & THEIR MOUNTING LUGS ON THE EXHAUST CASE.	NDI	
25.	VISUALLY INSPECT THE EXHAUST MIXER FOR CRACKING & THERMAL DETERIORATION.		
26.	VISUALLY INSPECT REAR BY-PASS DUCT FOR FRETAGE & WEAR, ESPECIALLY AT THE SOLEPLATE LINERS.		
27.	VISUALLY INSPECT ALL EXTERNAL PIPES & FITTINGS.		
28.	X-RAY INSPECT DIFFUSER CASE P3 MANIFOLD WELDS SECURING THE AIR OFFTAKE PIPES, THE FOUR OIL TUBE SUPPORT BOSSES AT BDC, & ALSO AT ANY EXISTING REPAIR WELDS. FILMS FROM THESE INSPECTIONS ALONG WITH ANY FOR NEWLY INCORPORATED REPAIRS ARE TO BE PROVIDED TO SPEY CUSTOMER SERVICE FOR REVIEW BY NASA.		
29.	VISUALLY INSPECT DIFFUSER CASE FOR DEFECTS.		
30.	DIMENSIONALLY INSPECT LEFTHAND GEARBOX GEAR JOURNALS, & PLAIN BEARINGS TO OHM FITS & CLEARANCES 'REFERENCE DIMENSIONS'.		
31.	OVERHAUL INSPECT MAIN OIL PUMP COMPONENTS TO OHM FITS & CLEARANCES 'REFERENCE DIMENSIONS'.		

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PART - II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:	LP COMPRESSOR	WORK ORDER NO.		SERIAL NO.	NASA

BULLETIN	CAT	DESCRIPTION	REMARKS	O/W	PCW	N/A	N/R
3889	R	FRONT PUMP SEAL OF IMPROVED MATERIAL.					
4990	R	INCREASED INTERFERENCE BETWEEN FRONT BEARING SUPPORT & HOUSING.					
5158	R	STATOR QUADRANTS WITH 'HAYNES 25' BUSHES & CHROMIUM PLATED DOWEL PINS.					
5181	R	STATOR QUADRANTS WITH TACK-WELDED RIVETS.					
5182	R	STAGE-1 STATOR QUADRANTS WITH DOWEL BOSSES HAVING INTEGRAL RIVETS.					
5270	R	LP OUTLET GUIDE VANE INNER FIXING BOLTS IN S/ABV MATERIAL.					
5449	R	BLADE PINS TEMPERED AT REDUCED TEMPERATURE.					
5521	R	STATOR VANE GROOVES COATED WITH SILASTIC OR SILCOSET.	ASSEMBLY				
5831	R+	FRONT ROLLER BEARING WITH CLEARANCE AT OUTER RACE LOCATION, S/B Sp72-892.	BEARING				
6033	R	STAGE-1 STATOR QUADRANTS WITH CHAMFERED DOWEL BOSSES & LP ROTOR RE-SET.					
6116	R	LP1C VANE INNER SHROUD RIVETS TACK WELDED.					
6269	R	LPC BLADES WITH 'ZYLAN' COATING.					

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:	HP COMPRESSOR	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	D/W	PCW	N/A	N/R
2789	R	HP1C BLADE IN TITANIUM WITH BUSH PIN HOLES.					
3071	R	HP1C BLADE RETAINING PINS WITH REDUCED CLEARANCE.					
3116	R	STRENGTHENED 8-9 & 11-12 DISC SPACERS.					
3444	R	HP STAGE-4 BLADES WITH CUT BACK LEADING & TRAILING EDGES.					
3664	R	BLEED VALVE INCREASED CLEARANCE & PL94 APPLIED TO SPLINES.					
3767	R	BLEED VALVE MECHANISM SUPPORT BRACKET DOWELS DELETED.					
3816	R	COVERS TO PARTIALLY SEAL OFF LEVER BEARINGS.					
3922	R+	NI-CAD COATING OF HPC VANES & CASE.	APPLY TO CASE ONLY				
4260	R	STAGES 2-7 BLADES WITH CHAMFERED LEADING EDGES.					
4340	R	STAGES 2-7 WET ASSEMBLED.	ASSEMBLY				
4422	R+	HP INLET GUIDE VANE OPERATING TRUNNIONS IN BRONZE/PTFE MATERIAL INSTEAD OF 'TUFNOL'.	OR MOD 5584				
4424	R	HP INLET GUIDE VANE PIVOT BUSHES IN 'VESPEL' MATERIAL.					
4474	R	REVISED BUILD TECHNIQUE FOR STAGES 1-11 DISCS.	ASSEMBLY				
4540	M	STAGES 2 & 3 ROTOR DISCS WITH INCREASED THICKNESS NECK & DIAPHRAGM.					
	R	STAGES 4 & 5 ROTOR DISCS WITH INCREASED THICKNESS NECK & DIAPHRAGM.					

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PART II		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:	HP COMPRESSOR CONT'D	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
4541	R	STRENGTHENED STAGES 10 & 11 ROTOR DISCS WITH STAGE 10 & 11 SPACER TO SUIT.					
4621	R	BLEED VALVE LEVER INNER DUST COVERS WITH LOCATION FEATURE.					
4697	R	INCREASED DIAMETER BOLTS SECURING DEFLECTOR PLATES, S/B Sp72-724.					
4709	R	STAGES 2 TO 12 ROTOR BLADES WITH SHOT-PEENED DOVETAIL ROOTS, S/B Sp72-727.					
4847	R	STAGE-6 ROTOR DISC WITH INCREASED THICKNESS NECK & DIAPHRAGM, S/B Sp72-755.					
4977	R	STAGES 4, 5, & 6 STATOR VANES WITH AEROFOIL THICKNESS INCREASED AT OUTER END, S/B Sp72-790.					
5273	R+	BLEED VALVE WITH STRENGTHENED ATTACHMENT LUGS, S/B Sp72-818.	SEE MOD 5474				
5474	R+	BLEED VALVE WITH INCREASED FILLETS RADIUS AT ATTACHMENT LUGS, S/B Sp72-849.	IF MOD 5273 NOT P/C/W				
5484	R	DELETION OF HP COMPRESSOR STAGE 12 SEAL AIR DEFLECTOR PLATE, S/B Sp72-856.					
5584	A	HPC IGV TRUNNIONS IN SP21 MATERIAL.					
5673	R	CENTER BEARING SUMP SECURED BY STUDS.					
5916	R	COOLING AIR GUIDE TUBE SEALING RINGS IN VITON(E.60C).	ASSEMBLY				
5963	R	BLEED VALVE - REVISED SETTING INSTRUCTIONS FOR ALUMINUM VALVE.	ASSEMBLY				

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PART II -		MANUFACTURERS BULLETIN COMPLIANCE RECORDS			
ENGINE SECTION:	HP TURBINE	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	PCW	N/A	N/R
2970	R	HP STAGE-1 BLADE WITH IMPROVED COOLING & LARGER NIMONIC BOLTS AT HP STAGE-1 NOZZLE VANES LOCATION.	MCA				
3886	R+	REPAIR SCHEME TO RECLAIM THE HP STAGE-1 ROTOR DISC WHEN THE BLADE RETAINING PLATE LOCATION GROOVE IS WORN.	REPAIR ONLY				
4021	R+	HP STAGE-1 NOZZLE GUIDE VANES WITH DOUBLE BULL-NOSED LEADING EDGE & GROUPED IN DOUBLE & TRIPLE ASSEMBLIES.	SEE MOD 5252 MCA				
4363	R	FLOW CHECK FOR HPT BEARING OIL JET.					
4412	R+	STRENGTHENED HP STAGE-2 TURBINE DISC LOCATION SLEEVE WITH THRUST WASHER DELETED.	N/A IF MOD 5870 OR 6142 C/W				
4469	R+	LP COOLING AIR OUTLET OIL TRAP.	ALSO C/W MOD 4734				
4496	R	HPT BEARING OIL FEED TUBE WITH INTEGRAL SPIGOT AT SPLIT CONNECTOR.					
4701	R+	REPAIR SCHEME TO RECLAIM THE HP STAGE-1 ROTOR DISC WHEN THE BLADE RETAINING PLATE LOCATION GROOVE IS WORN.	REPAIR ONLY				
4734	R	LP COOLING AIR OUTLET OIL TRAP WITH MODIFIED TUBE.					
4765	R	HP TURBINE BEARING SUPPORT, BEARING HOUSING & DIFFUSER CASE SECURED BY 0.250 INCH DIAMETER WAISTED BOLTS.					
4774	R+	HPT BEARING WITH STRENGTHENED OIL SEAL RING HOUSING & IMPROVED SEALING.	ALSO C/W EB-001 BEARING				
4921	R+	ALUMINIZED HP2 TURBINE BLADES.	SEE MOD 5581 MCA				

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PART I - MANUFACTURERS BULLETIN COMPLIANCE RECORDS					
ENGINE SECTION	HP TURBINE CONT'D:	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CATE	DESCRIPTION	REMARKS	C7/K	PCW	IN/A	IN/R
5252	R	STAGE-1 HP NOZZLE VANES WITH FILM COOLING HOLES AT LEADING EDGE & NEW AIR GUIDE TUBE.	MCA				
5282	R+	HPT BEARING WITH STRENGTHENED OIL SEAL RING HOUSING & IMPROVED SEALING.	ALSO C/W EB-001				
5581	R	PARTIALLY ALUMINIZED HP2T BLADES.	MCA				
5582	R	HPT BEARING OUTER RACE KEYED TO HOUSING & WITH AXIAL NIP DELETED.	BEARING				
5642	R+	HP1 BLADES WITH REDUCED SHROUD CLEARANCE.	C/W TI-034 MCA				
5824	R	HP1 DISC WITH INCREASED BLENDING ON BUCKET GROOVES.					
5843	R	HAND HOLE COVERS WITH ADDITIONAL BOLTS.					
5870	A	HP2T DISC SLEEVE STRENGTHENED.					
5892	R+	HP1T BLADES WITH CABOT 694 ON SIDEFACES.	C/W TI-034 MCA				
5987	R	HAND HOLE COVERS WITH 'D' WASHER DELETED.					
6112	R+	DELETION OF MOD 6001.	IF MOD 6001 EMBODIED				
6142	A	HP2TD SLEEVE IN EFR MATERIAL.					
6162	R	HP1T BLADE LOCKPLATES WITH ANTI-FRETTAGE WIRE.					

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ENGINE SECTION:	EXTERNAL /RHGB	WORK ORDER NO.		SERIAL NO.	

BULLETIN	CAT	DESCRIPTION	REMARKS	C/W	ECW	N/A	N/R
4736	R	ORIFICE PLATE FITTED AT SPLIT CONNECTION OF IGB TO DRAINS TANK VENT PIPE.					
4775	R	HPT SCAVENGE PUMP WITH INCREASED CAPACITY.					
4855	R	AIR SUPPLY RESTRICTOR TO D.C. GENERATOR SEAL WITH INCREASED DIAMETER.					
4965	R+	FUEL DRAINS BLANKED OFF AT BY-PASS DUCT & HP SHUTOFF VALVE.	ALSO C/W MOD 5298				
5073	R	HP PILOT FUEL FEED TUBE RE-RUN TO SHUTOFF VALVE FROM ALTERNATIVE CONNECTION ON FUEL FLOW REGULATOR.					
5298	R	REMOVAL OF MOD 4965 BLANKING PLATE.					
5390	R	HP ROTOR THRUST BEARING RETURN OIL TRANSFER TUBE WITH BY-PASS HOLE.					
5546	R	CONTINUOUS FUEL BLEED SYSTEM.					
5639	R	INTRODUCTION OF OIL FILTER ELEMENT ANTI-ROTATION WASHER.					
5729	R	HPT BEARING RETURN OIL TRANSFER TUBE WITH BY-PASS HOLE.					
6022	R+	THROTTLE CONTROL ROD WITH LARGER DIAMETER THREADS.	DELETE MOD 5649				
6114	R	FRONT MOUNT NUTS UNPLATED.					
6163	R	LPT SCAVENGE PUMP WITH DRILLED BOBBIN.					
Sp73-193	R	INSPECTION OF FUEL FLOWMETER MOUNT ELBOW.					

SOW Attachment 3
NASA Accessory Overhaul Specifications
for
Spey Engines Mk 511-8

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PART: 11	MANUFACTURERS BULLETIN COMPLIANCE				
SUNNY	FUEL FLOW REGULATOR (B)	DATE:		M/O:	
CUSTOMER		P/N:		S/N:	

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PART #	MANUFACTURERS BULLETIN COMPLIANCE				
UNIT #	FUEL FLOW REGULATOR (C)	DATE:		W/O:	
CUSTOMER		P/N:		S/N:	

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UNIT:	FUEL FLOW REGULATOR (G)	DATE:		H/O:	
CUSTOMER:		P/N:		S/N:	

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DATE _____

CUSTOMER

INTRODUCTION OF BLANKET
MOD CP4284, CP4407, CP4554,
CP4737, CP4929 & CP6435

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PART II - MANUFACTURERS BULLETIN COMPLIANCE					
UNIT	FUEL FLOW REGULATOR (I)			DATE	
CUSTOMER				F/N	

MOD OR SERVICE BULLETIN	CATEGORY				DESCRIPTION	REMARKS	C/N	FCH	NR
	CASC 208	CASC	CASC	CASC					
CP5926 73-272 (RR5974)	R				CARBON SPHERICAL THRUST BEARING MANUFACTURED IN EY9106BY MATERIAL.				
CP6188 73-279 (RR6088)	R				DELETION OF NEW GOVERNOR SPRING AND THROTTLE CAM PROFILE.				
CP6376 73-286 (RR6140)	R				KARON COATED AIR SEALS.				
CP6227 73-280 (RR6102)	R				ALTERNATIVE VMO PLUNGER WHICH IS TUNGSTEN CARBIDE PLATED.				
CP6228 73-281 (RR6103)	R				ALTERNATIVE PRESSURE SLEEVE WHICH IS TUNGSTEN CARBIDE PLATED.				
CP6126 73-282 (RR6063)	CSI +				INTRODUCTION OF TUNGSTEN CARBIDE COATED VMO PLUNGER + BALANCE SLEEVE.	FOR REFER- ENCE ONLY.			
CP6247 73-285 (RR6191)	R				REVISED CAMSHAFT ASSEMBLY.				
CP6376 73-286 (RR6140)	R				KARON COATED AIR SEALS.				
CP6435 73-291 (RR6169)	R				RE-DESIGNED TRANSFER GEAR ASSEMBLY.				
CP6444 73-289 (RR6173)	R				P3 CONNECTION KLINGERSIL GASKETS.				
PART III					Contractor BULLETIN COMPLIANCE				
					NONE ISSUED				
PART IV					FAA AIRWORTHINESS DIRECTIVES				
					NONE ISSUED				

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PART 11 MANUFACTURERS BULLETIN COMPLIANCE					
INDEX:	HP FUEL PUMP (A)		DATE:		S/O:
CUSTOMER:			P/R:		S/T:

MOD OR SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	C/W	PCW	NR
	(G)						
	119/						
	129/						
	146/						
	147/						
	149						
CP2509 73-40 (RR2749)	A		PROVISION FOR MAGNETIC CHIP DETECTOR IN PUMP BODY.				
CP2696 73-79 (RR3015)	R		IMPROVED PISTON SPRINGS.				
CP3060 73-127 (RR3847)	R+		INTRODUCTION OF A DISC BETWEEN THE ROTOR END FACE AND PORT INSERT.	S/S BY CP4173			
CP3189 73-160 (RR4371)	R		CARBON PISTON LINERS IN PUMP ROTOR.	CP3632 ESSENTIAL. C/W BY ROTOR REPLACE FROM ROTABLE POOL.			
CP3632 73-189 (RR4643)	R		REVISED ROTOR WITH REPOSITIONED DRILLINGS.				
CP4173 73-212 (RR5091)	R+		BALANCED PUMP ROTOR WITH TUNGSTEN CARBIDE ROTOR INSERT AND PORT INSERT.	AD 78-16-07 REFERS (511- 8 ONLY)			
CP4404 73-224 (RR5219)	R		REVISED METHOD OF WIRE LOCKING RELIEF VALVE.				
CP4761 73-246 (RR5370)	A		ECCOBONDED CARBON TOPPED SLIPPERS.	MIXING OF PRE & POST MOD IS PERMIS- SIBLE.			
Sp73-273	R		INSPECT CAMPLATE HOUSING AND BODY FOR LINK PIN WEAR.				

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PART: FI		MANUFACTURER'S BULLETIN COMPLIANCE				
UNIT:	WP FUEL SHUT-OFF COCK (B)		DATE:		N/C:	
CUSTOMER:			P/N:		S/N:	

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PART II MANUFACTURERS BULLETIN COMPLIANCE				
UNIT:	GP GOVERNOR	DATE:		W/O:
CUSTOMER:		APR:		S/N:

HOU OR SERVICE BULLETIN	CATEGORY			DESCRIPTION	REMARKS	C/H	PCN	MR
	LPG 115	LPG	LPG					
CP2548 73-78 (RR3035)	R			INTRODUCTION OF IMPROVED LOCKING OF DRIVE SHAFT BACKSTOP.				
CP2745 73-77 (RR3045)	R			INTRODUCTION OF A RIGID SLIDER BLOCK DRIVE.				
CP2914 73-106 (RR3451)	R			INTRODUCTION OF A RIGID SLIDER BLOCK DRIVE ON THRUST COLLAR.	S/S BY CP4252			
CP3162 73-143 (RR4028)	R			INTRODUCTION OF A REVISED COOLING FLOW RESTRICTOR AND STRAINER.				
73-A205	R			INSPECT SLIDER BLOCKS.	S/S BY CP4252			
CP4252 73-214 (RR5036)	R			INTRODUCTION OF BALL RACES TO SPRING SEAT ASSEMBLY.				
PART III Contractor BULLETIN COMPLIANCE								
				NONE ISSUED				
PART IV FAA AIRWORTHINESS DIRECTIVES								
				NONE ISSUED				
				511-8 - LPG 115				

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PART II MANUFACTURERS BULLETIN COMPLIANCE				
UNIT	AFC - RPM SIGNAL TRANSMITTER		DATE	
CUSTOMER		F/E		S/N

MOD OR SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	C/A/E	FCH	ENR
	ACA 101	ACA					
CP2478 75-4 (RR2631)	R		INTRODUCTION OF A RESISTOR ORIFICE IN THE SUCTION LINE TO THE UNIT.				
CP2481 75-3 (RR2701)	R		INTRODUCTION OF CLOSE LIMITS ON CALIBRATION.				
CP2816 75-5 (RR3467)	R		INTRODUCTION OF STRIP HINGE MOUNTING FOR GOVERNOR LEVER.				
CP3001 75-6 (RR3628)	R		REVISED TEST SCHEDULE.				
CP3065 75-8 (RR4178)	R		REVISED CARBON FACE SEAL ARRANGEMENT.				
CP3159 75-7 (RR4164)	R		AFCR - SIGNAL TRANSMITTER INTRODUCTION OF RUBBER COATED SHAFT SEAL.				
CP3236 75-9 (RR4195)	R		REVISED SHAFT OIL SEAL LEAK TEST.				
CP3466 75-10 (RR4512)	A		BLANKET MOD COVERING CP2478, 2816, 3001, 3065, & 3236.				
CP4040 75-11 (RR4928)	R		MODIFIED QUILLSHAFT AND JUMP RING.				
CP6362 75-13 (RR6128)	A		CHANGE OF DIAPHRAGM FABRIC.				
PART III			Contractor BULLETIN COMPLIANCE				
			NONE ISSUED.				
PART IV			FAA AIRWORTHINESS DIRECTIVES				
			NONE ISSUED.				
			511-8 - ACA 100-103				

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PART II	MANUFACTURERS BULLETIN COMPLIANCE			
UNIT	AIRFLOW CONTROL RAM (B)	DATE		N/O
CUSTOMER		P/N		S/S

MOD OR SERVICE BULLETIN	CATEGORY				DESCRIPTION	REMARKS	C/W	PCW	NR
	511-5								
4307	A				SHORT PIGTAIL ON THERMOPHIAL.				
4670 75-116	R				AFCR "BELLO FRAM" DIAPHRAGM WITH IMPROVED SEALING AND REDUCED NIP.				
3387 75-97	R				CONTROLS - B/V RAM TO IGVs & B/V OPERATING LINKAGE WITH 'D' HEADED PIVOT PINS SECURING BY NUTS.				
5000 72-785	R+				REVISED SETTING INSTRUCTIONS FOR HP COMPRESSOR INLET GUIDE VANE MECHANISM.	C/W ONLY IF MOD 3971 PCW & CON-CURRENTLY W/ENGINE.			
5349 75-140	R				CARBON BUSHED STAGE 1 OPERATING PIN SLEEVE.				
5451 75-141	R				IMPROVED SUPPORT BRACKET.	S/S BY 5546			
5393 75-144	R				INTRODUCTION OF SERVICE ADJUSTMENT LIMITS.				
5546 75-145	R				INTRODUCTION OF CONTINUOUS FUEL BLEED SYSTEM.				
6111 75-157	R				INTRODUCTION OF 'COLD STOP' IN THERMAL CONTROL.				
6137 75-158	R				RIG TEST SCHEDULE WITH REVISED IGV WHIRL SETTINGS LIMITS.				
6167 75-159	A				TCU WITH STAINLESS STEEL CAPSULE ASSEMBLY.				
PART III					Contractor BULLETIN COMPLIANCE				
PART IV					FAR AIRWORTHINESS DIRECTIVE				
					NONE ISSUED.				

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PART II: MANUFACTURERS BULLETIN COMPLIANCE					
UNIT:	GROUND COOLING EJECTOR VALVE (A)			DATE:	
CUSTOMER:				P/N:	
				S/N:	

MOD OR SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	R/C/N	PCW	NR
	6213	6242					
1524 75-22 (4010U 75-8)	R		ANTI-ICING CONTROL VALVES YELLOW IDENTIFICATION BAND ON CASE.				
2571 75-46 (4232U 75-12)	R		SQUARE HEADED VALVE STEMS & CONCAVE SEATINGS ON HOT AIR & GROUND COOLING EJECTOR VALVES.				
2648 75-52 (4274R 75-18)	A		BAULKING FEATURE IN SOLENOID CASE.				
2670 75-58 (4295U 75-14)	A		MODIFIED ADJUSTING NUT AND REGULATOR.				
2718 75-59 (4299U 75-15)	A		AIR SHELL WITH CASE OUTLET FLANGE.				
3553 (4429U 75-22)	R+	R+	GENERAL GROUND COOLING EJECTOR VALVE SEALING FEATURES.				
4193 (4508U 75-30)	R	R	PL 94 ANTI-CORROSIVE TREATMENT.				
(4548U 75 31)	A		LONGER PUSHROD FOR SOLENOID ASSEMBLY.				
4650 75-32 (4631U 75-32)		A	INTRODUCTION OF REGULATOR BUSH WITH REDUCED DIAMETER AIR BLEED HOLES.				
4768 (4680U 75-39)		R	INTRODUCTION OF THINNER NUTS.				
4712 (4681U 75-40)	R	R	INTRODUCTION OF STAINLESS STEEL GASKET AT TRANSFER VALVE BUSH & FILTER BOLT.				
4564 (4500U 75-43)		A	AIR CONTROL VALVES - NEW SOLENOID COIL ASSEMBLIES.				
(4785U 75-49)	A		NEW MAIN HOUSING ASSEMBLIES & TAB WASHERS.				
(4797R 75-50)	A		SELF-LOCKING NUTS ON SENSING PROBE.				

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PART II MANUFACTURERS BULLETIN COMPLIANCE					
UNIT:	GROUND COOLING EJECTOR VALVE (B)		DATE:		N/O:
CUSTOMER:			F/R:		S/N:

MOD OF SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	C/H	PCM	NR
	6213	6242					
(4978U 75-51) (RR 5217)	R	R	INTRODUCTION OF POTTING TO PROTECT SOLENOID AGAINST POSSIBLE INGRESS OF WATER.				
5043U 75-56	A		ALTERNATE DOMES N8863430/1 & N8863248/2.				
5044 75-54 (RR 5385)	A		ALTERNATE PRESSURE CHAMBER.				
5045U 75-55 (RR 5458)	A		INTRODUCTION OF STAINLESS STEEL DOME.				
5056U 75-52 (RR 5383)	R	R	CHECK INLET FLANGE THICKNESS.				
5171U 75-60 (RR 5563)	A		INTRODUCTION OF NEW COIL.				
129854 75-53	A		INTRODUCTION OF ASSEMBLED & PRE-SET VALVE ASSEMBLY.				
5168U 75-61	A	A	REVISED AIR SHELL.				
PART III			Contractor BULLETIN COMPLIANCE				
			NONE ISSUED.				
PART IV			FAA AIRWORTHINESS DIRECTIVES				
			NONE ISSUED.				
			511-8 MOD 6213 - MOD 6242				

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PART-ET MANUFACTURERS BULLETIN COMPLIANCE					
UNIT	ANTI-ICE VALVE (A)		DATE		N/O
CUSTOMER			P/A		S/N

MOD OR SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	C/N	PCW	NR
	6212	6241					
1524 75-22 (4010U 75-8)	R		ANTI-ICING CONTROL VALVES YELLOW IDENTIFICATION BAND ON CASE.				
2571 75-46 (4232U 75-12)	R		SQUARE HEADED VALVE STEMS & CONCAVE SEATINGS ON HOT AIR & GROUND COOLING EJECTOR VALVES.				
2648 75-52 (4274U 75-18)	A		BAULKING FEATURE IN SOLENOID CASE.				
2670 75-58 (4295U 75-14)	A		MODIFIED ADJUSTING NUT & REGULATOR.				
2718 75-59 (4299U 75-15)	A		AIR SHELL WITH CAST OUTLET FLANGE.				
4192 (4488U 75-27)	R	R	SEALING OF HOUSING AGAINST WATER INGRESS.				
4308 75-107	A		ROTAX AIR CONTROL VALVES WITH COMPONENTS IN ALUMINUM 100 MATERIAL REPLACED WITH STEEL.				
4193 (4508U 75-30)	R	R	PL.94 ANTI-CORROSIVE TREATMENT.				
4564 (4500U 75-43)		A	AIR CONTROL VALVES - NEW SOLENOID COIL ASSEMBLIES.				
4768 (4680U 75-39)		R	INTRODUCTION OF THINNER NUTS.				
4712 (4681U 75-40)	R	R	INTRODUCTION OF STAINLESS STEEL GASKETS AT TRANSFER VALVE BUSH & FILTER BOLT.				
(4785U 75-49)	A		NEW MAIN HOUSING ASSEMBLIES & TAB WASHERS.				
			511-8 MOD 6212 - MOD 6241				

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PART III MANUFACTURER'S BULLETIN COMPLIANCE					
UNIT	ANTI-ICE VALVE (B)		DATE		W/O
CUSTOMER			P/N		S/N

MOD OR SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	C/H	PCW	NR
	5112	5241					
(4797U 75-50)	A		SELF-LOCKING NUTS ON SENSING PROBE.				
(5044U 75-54) (RR5385)	A		ALTERNATE PRESSURE CHAMBER.				
(5056U 75-52) (RR5383)	R	R	CHECK WALL THICKNESS OF INLET FLANGE.				
(4978U 75-51) (RR5217)	R	R	POTTED SOLENOID TO PREVENT WATER INGRESS.				
(5043U 75-55)	A		ALTERNATE DOMES N88630/1 & N8863248/2.				
(5045U 75-55) (RR5458)	A		INTRODUCTION OF STAINLESS STEEL DOME.				
AMMEND- MENT 128064 75-26	R	R	RE-ROUTE OF LEAD FROM SOLENOID COIL.				
129854 75-53	A		INTRODUCTION OF ASSEMBLED & PRE-SET VALVE ASSEMBLY.				
(4631U 73-32) (RR4650)		A	INTRODUCTION OF REGULATION BUSH WITH REDUCED DIAMETER BLEED HOLES.				
(5171U 75-60) (RR5563)	A		INTRODUCTION OF NEW COIL.				
(5168U 75-61)	A	A	REVISED AIR SHELL.				
PART III			Contractor BULLETIN COMPLIANCE				
			NONE ISSUED.				
PART IV			FAA AIRWORTHINESS DIRECTIVES				
			NONE ISSUED.				

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ISS. NO. REV. NO.		DATE	

[illegible]

MOD OR SERVICE BULLETIN	CATEGORY				DESCRIPTION	REMARKS	C/M	FCM	NR
	511-B								
4500 73-156	R				FUEL NOZZLES - ALUMINIZED FRONT SHROUD CHAMFER.	S/S BY 5739			
5111 73-164	R				"RETIMET" FILTER IN SPRAY NOZZLE.				
5212 73-165	SE				FUEL SPRAY NOZZLE WITH S/CNT SLEEVES FITTED IN PRIMARY FUEL PASSAGE.				
5739 73-187	R+				NOZZLE NUT.	ALSO SEE 6175			
6175 Sp-MISC -162	A				INTRODUCTION OF NOZZLE NUT HARDNESS CHECKED AT MANUFACTURE.				
PART III					Contractor BULLETIN COMPLIANCE				
TI-109	R				FUEL SPRAY NOZZLE INSPECTION ACCEPTABLE CRITERIA.				
TI-126	R				RETAINING NUT, HARDNESS CHECK.				
PART IV					FAA AIRWORTHINESS DIRECTIVES				
					NONE ISSUED.				

[illegible]

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ISS. NO. REV. NO.		DATE	

[illegible]

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ISS.NO. REV.NO.		DATE	

PART II		MANUFACTURERS BULLETIN COMPLIANCE			
UNIT	THEMOCOUPLES & HARNESS (B)	DATE		N/O	
CUSTOMER		F/N		S/N	

[illegible]

[illegible]

[illegible]

[illegible]

[illegible]

[illegible]

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PART II MANUFACTURER'S BULLETIN COMPLIANCE					
UNIT	OIL LP WARNING SWITCH (SMITHS TYPE 1137 & 1138)			DATE	
CUSTOMER				P/R	

MOD OR SERVICE BULLETIN	CATEGORY			DESCRIPTION	REMARKS	C/H	PCW	NR
	511-B							
2334 79-8	A			ENGINE INDICATING CHANGE OF MATERIAL FOR OIL LOW PRESSURE WARNING SWITCH PUSH ROD.				
PART III				Contractor	BULLETIN COMPLIANCE			
				NONE ISSUED.				
PART IV				FAA AIRWORTHINESS DIRECTIVES				
				NONE ISSUED.				

NA-AO-4004-S		OVERHAUL SPECIFICATION AND COMPLIANCE RECORDS		39	39
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ISS. NO.	REV. NO.			DATE	

PART II MANUFACTURER'S BULLETIN COMPLIANCE					
UNIT	EJECTOR PUMP		DATE		H/O
CUSTOMER			P/N		S/N

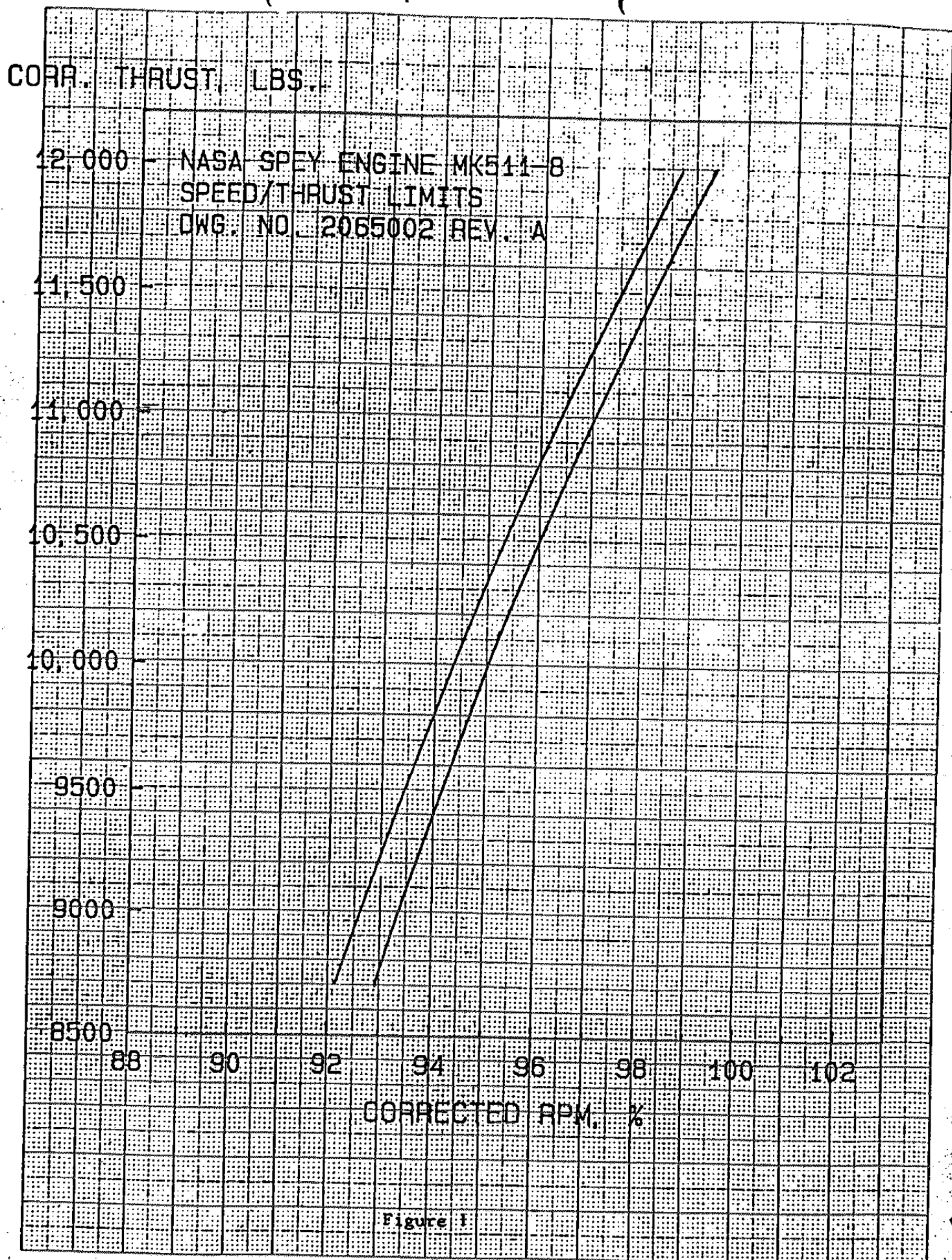
MOD OR SERVICE BULLETIN	CATEGORY		DESCRIPTION	REMARKS	C/N	PCP	NR
	EJP 100	EJP 101					
CP4980 73-251 (RR 5419)	R		REVISED ORIFICE UNION AND BODY.				
CP4981 75-250 (RR 5420)	R		STAINLESS STEEL FLOAT.				
CP5160 73-260 (RR 5725)	A		INTRODUCTION OF EJP 101.				
CP6719 73-292 (RR 6289)	R	R	IMPROVED SHIM LOCATION ON ORIFICE BOBBIN.				
CP6749 73-293 (RR 6306)	R	R	INTRODUCTION OF A REMOVABLE FILTER TO THE EJECTOR NOZZLE.				
PART III			Contractor BULLETIN COMPLIANCE				
			NONE ISSUED.				
PART IV			FAA AIRWORTHINESS DIRECTIVES				
			NONE ISSUED.				

SOW Attachment 4

NASA Spey Engine MK 511-8

Speed Thrust Limits

Drawing Number 2065002, Revision A

DIETZGEN CORPORATION
MADE IN U.S.A.NO. 341-M DIETZGEN GRAPH PAPER
MILLIMETER

SOW Attachment 5

NASA Spey Engine MK 511-8

Starting Flow Requirements

FUEL FLOW REGULATOR
TYPE CASC 174, 206
Starting Flow Requirements

12-5-88

REFERENCE

Lucas Overhaul Manual 73-23-00

WORK ORDER

CUSTOMER

P/N

S/N

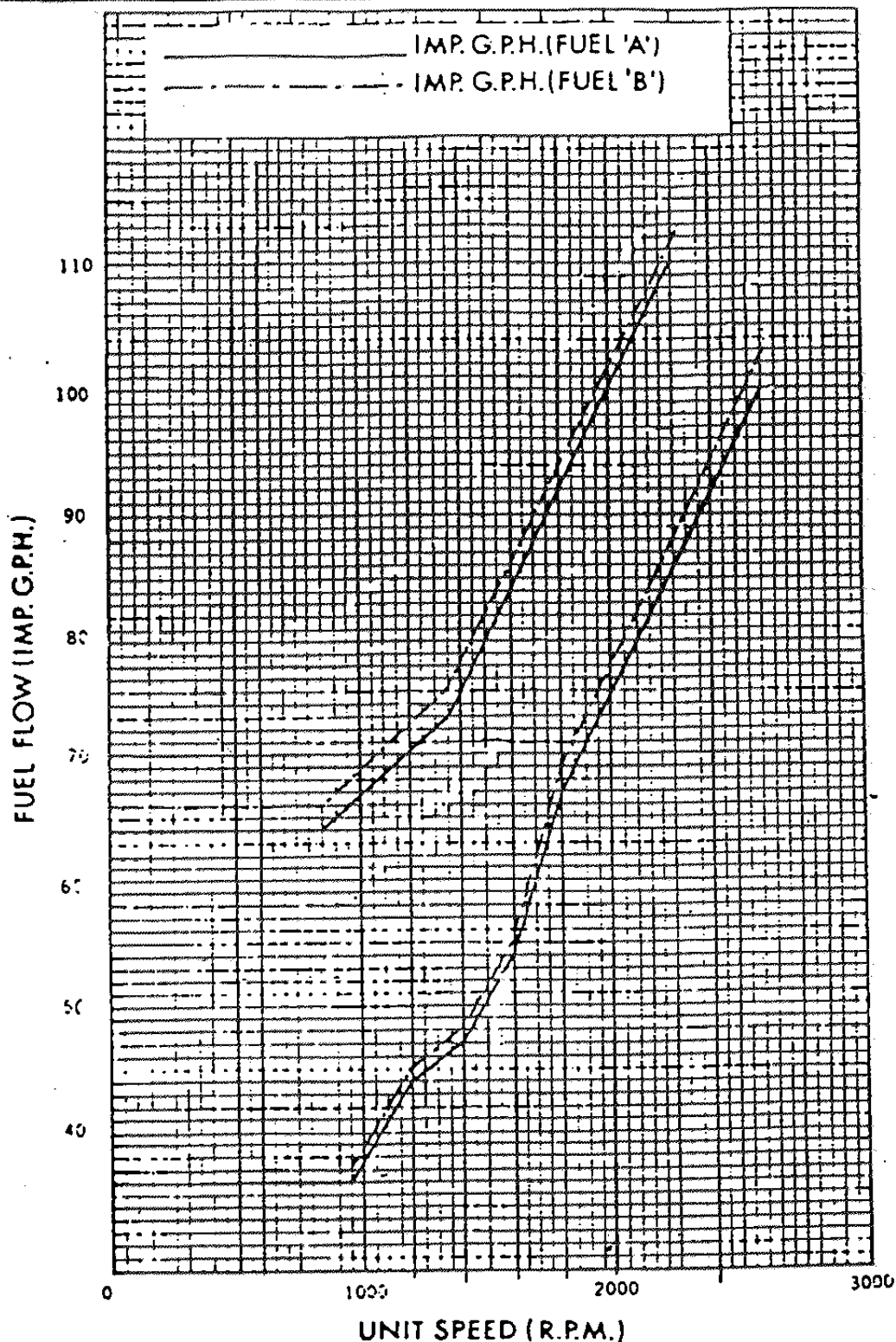
REASON FOR REMOVAL

TTSN/TSO

RECORD FLOWS

500 _____
600 _____
1000 _____
1200 _____
1400 _____
1600 _____
1800 _____
2000 _____
2400 _____
2800 _____

Mechanic



SOW Attachment 6

Modification Category and Compliance Codes

MODIFICATION CATEGORY AND COMPLIANCE CODES

M	(Mandatory) (See Note 2)	(This modification is classified as Mandatory and must be accomplished. Historical records furnished to the customer must reference this compliance listing the applicable Airworthiness Directive (AD) Note, Alert Service Bulletin (SB) and/or modification and SB Number. No engine may leave the shop without this compliance.
R	(Required)	Incorporation of this modification is required. No engine may leave the shop without compliance except by the authority of NASA JSC.
R+	(Required + Special Remarks)	Incorporation of this modification is required; however, special remarks are applicable relative to compliance categories or compliance effectivity. No engine may leave the shop without compliance when applicable as instructed by "Special Remarks" except by the authority of NASA JSC.
CR	(Customer Request)	Incorporation of this modification is to be accomplished only when requested by the customer. Modification must be referenced as "required" on face of applicable work order.
A	(Attrition)	Incorporation of this modification is to be accomplished when the part involved requires renewal because of its condition and all stock of pre-mod parts are no longer available.
SE	(Service Evaluation)	Incorporation of this modification is required for service test only when referenced on the applicable work order.
C/W	(Complied With)	This code will be used any time a modification, service bulletin and special work spec is complied with by the contractor or subcontractor.

PCW (Previously
Complied
With)

This code will be used when it is determined that a modification, service bulletin, contractor bulletin and/or special work specification was not accomplished due to being previously accomplished prior to receipt of the engine on the current job. Bulletins and mods that are repeat compliances will be stamped both "C/W" and "PCW".

N/A (Not
Applicable)

This code will be used when it is determined that any modification, service bulletin, contractor bulletin and/or special work specification is not accomplished because it is not applicable due to the engine model or type and/or configuration of the parts installed. This code will also be used on Category "CR" and "SE" when work order instructions do not request compliance.

N/R (Not
Required)

This code will be used when it is determined that any modification, service bulletin, contractor bulletin and/or special work specification is not accomplished due to the condition of existing parts. Applicable to Category "A": Bulletins and/or on Category "R+" Bulletins when remarks information allows compliance only due to condition of existing parts. NASA JSC'S approval is required to utilize this code on any Required (R) modification that cannot be accomplished for some reason other than previously referenced.

NOTE 1: Multiple compliance categories will be indicated when applicable.

NOTE 2: Inspection sign-off of AD Notes as PCW or N/R can only be made if determined by physical examination of the part. Where this determination is made by review of the log book or previous record, the compliance column must be signed off by an authorized signature.